

Date: Wednesday, 22/10/2008 11:56:18 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: CAP		
Job Number	: 42806			Part Number	: D2855		
Estimate Number	: 10519			Drawing Number	: D2855 REV. A		
P.O. Number	:			Project Number	: N/A		
This Issue	: 22/10/2008	S.O. No.	:	Drawing Revision	:		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: PURCHASED PARTS	Due Date	: 06/01/2009	Qty:	12
Previous Run	: 35920			Um:	Each		
Written By	:						
Checked & Approved By	: <u>JUL 08/10/22</u>						
Comment	: Est: B 00.06.22 Added receiving step & removed P/O for powder coat EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
		 Comment: PURCHASING Issue P/O: <u>7431</u> <i>C 08/10/23</i> Cast per Dwg D2855 Material Release Note Required (12)
2.0	D2855P	Cap
		 Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) CAP
3.0	PACKAGING 1	PACKAGING RESOURCE #1
		 Comment: PACKAGING RESOURCE #1 Recieve & Inspect for Transit Damage Ensure Material Release Note is attached <i>P 08/10/20 (12)</i>
4.0	QC6	DIMENSIONAL CHECK
		 Comment: DIMENSIONAL CHECK <i>S 08/10/20 (12)</i>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		 Comment: SMALL & MEDIUM FAB RESOURCE 1 1- Drill as per Dwg D2855 using DT8235 2- Open holes to 19/64" 3- Deburr <i>E 08/12/03 (12)</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S. oselios (12)

7.0 POWDER COATING

POWDER COATING



M102316

(12X)

Comment: POWDER COATING



Powder Coat **SANDTEX GREEN**



(Ref: 4.3.5.1) as per QSI 005 4.3

M-1 08/12/05

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



HJ

Comment: INSPECT POWDER COAT

08-12-05

(12)

9.0 ALS71032225

INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)

INSERT

Pick:

Qty Part Number

Description

Batch

2 ALS7-1032-225

Insert

M100621

or AKS7-1032-225

or ALS4-1032-225

or AKS4-1032-225

g1

9.1 ALS41032225

Insert



Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)

Insert

g1

10.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Inserts as per Dwg D2855

HJ

11.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-12-05

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

12.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Finishing

90 08-12-08

12

13.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-12-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

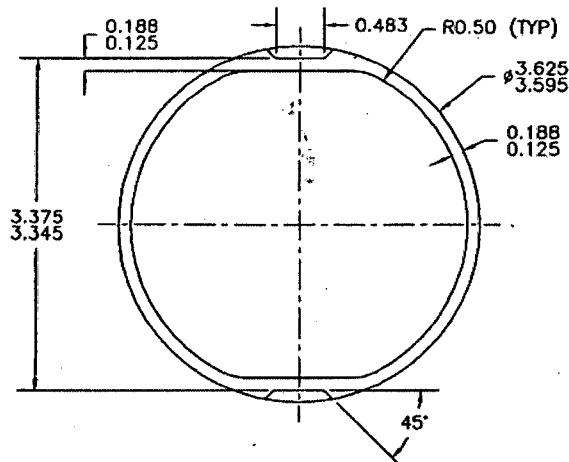
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

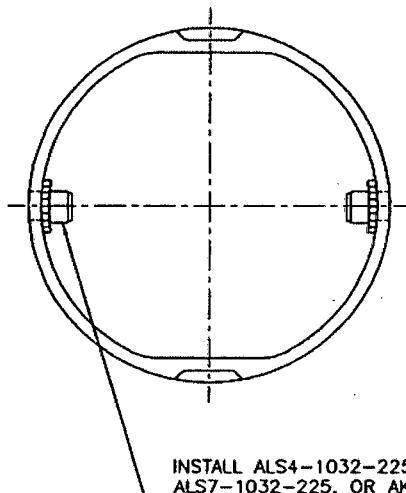
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D2855 CASTING DETAIL



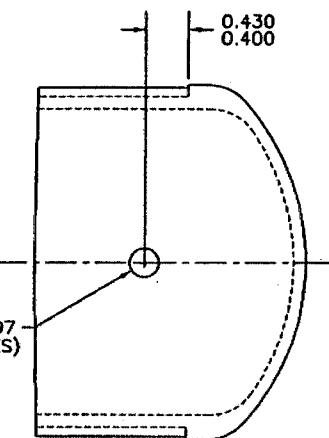
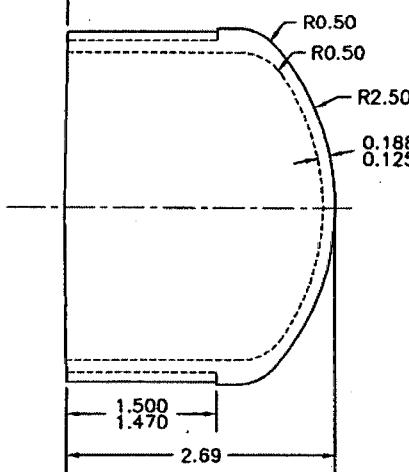
D2855 FINISHING DETAIL



INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR ALS7-1032-225, OR AKS4-1032-225) INSERT ON INSIDE OF CAP (AFTER POWDER COAT) (2 PLACES)

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
MATERIAL: CAST ALUMINIUM ALLOY A356.2 (F)

1° TAPER



RELEASED
(18.12.14 DS)

DART

QA COPY
DATE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
DATE	DATE	TITLE
	JK	D2855
98.12.12		CAP
A	96.12.12	NEW ISSUE (WAS D2575 REV. E)

REV. A
SHEET 1 OF 1
SCALE
NIT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 442200

Aluminum Foundry Ltd

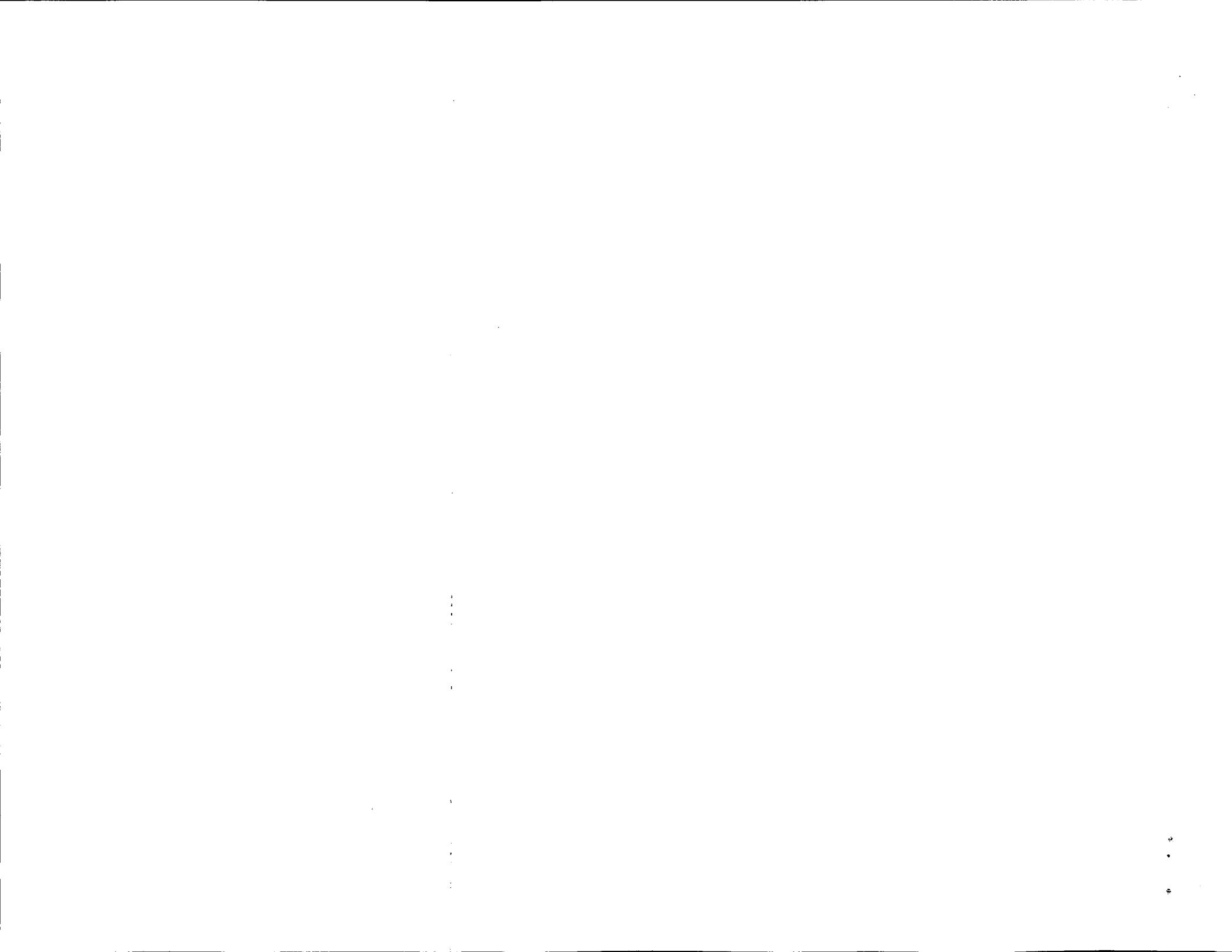
714-716 Calais
Dorval, Québec H9P 2P3
Tel: (514) 631-1331
Fax: (514) 631-8448

Packing Slip

Packing Slip No.: 32829
Date: Nov 21, 2008
Page: 1

Sold to:	Ship to:
DART AEROSPACE 1270 ABERDEEN STREET HAWKSLEY, ONTARIO K6A 1K7	DART AEROSPACE 1270 ABERDEEN STREET HAWKSLEY, ONTARIO K6A 1K7
Order No.: 7431	Sold By:
Shipped By: FEDEX	Ship Date: Nov 21, 2008
Tracking No.: 8491 8012 0924	

Item No.	Unit	Description	Quantity
Z098046	Each	D2855 CAP REV.A	30
Comment:			



**CERTIFICAT DE CONFORMITÉ
CERTIFICATE OF COMPLIANCE**

**FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTD
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD**

714-716 CALAIS, DORVAL, QC H9P-2P3
TEL: (514) 631-1331 FAX: (514) 631-8448

Expédié à
Shipped

DART AEROSPACE

A.F. & P.W. Série no./Serial no.

1270 Aberdeen Street

Packing

Date: 21/11/2008 Slip No. 32829

Hawsbury, ON, K6L 1K7

Votre No. Commande 00007431

Your order No. _____

Ceci est pour certifié que le matériel liste ci-dessous est selon les spécifications du bon d'achat ci-haut, et que les documents en evidence des rapports et certificats de détaillante sont en filière dans notre bureau.

This is to certify that the material listed below is according to your specifications on above P.O. and that documentary evidence of the tests or release certificates from the original supplier are on file in this office.

Quantité Quantity	Description	Note No. Our No.	Specifications	Note d'autorisation Incoming Release note
30	D 2855 CAP <i>S</i> <i>05/11/08</i>	Z098046	A356.2	ingot#851118

**Analyses
Analysis (as in ingot)**

(Si)	7.00%	(Al)	balance
(Fe)	0.06%		
(Cu)	0.00%		
(Mn)	0.00%		
(Mg)	0.42%		
(Zn)	<0.01%		
(Ti)	0.16%		

Donnée
Yield :

Résistance à la tension :
Tensile Strength :

Allongement par pouce carré :
P.S.I. Elongation : %

Pour et au nom de
For and on behalf of :

**FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTD
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD**

Dept/Dep :
Par/Per : R. Morris

Coc-100

